

Work Order ID 85863

June-18-12 10:50:02 AM

85863

Page 1

Item ID: D2052

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Mounting Bracket

Stop ***NS2***

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12/06/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2052

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2052

Dwg Rev: D

Prog Rev: D

****grain direction along 3.878" ****

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Sm 12-6-20

12 0 Sm 12-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85863

Page 2

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 15/06/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 02/07/2012 **Req'd Qty:** 12.00

12

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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Page 3

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 Start Date: 15/06/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/07/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

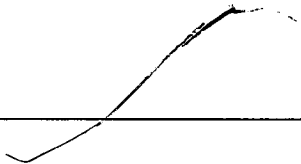
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				12			NG 12-6-25
Hand Finishing									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:50								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 9:20								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

12X ϕ M-L 12/07/03
 12 ϕ 12/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Item Name: Mounting Bracket

Start Date: 15/06/2012 Start Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00				12x			SD
Packaging									12-7-3
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							12/7/4
Quality Control									

SMF
12-07-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-18-12 10:50:06 AM

Page 1

Work Order ID: 85863

85863

Parent Item: D2052

D2052

Parent Item Name: Mounting Bracket

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C01.08.21 Added Finishing SM(Issue this IPP with part number D2053)
IPP Rev:D now water jet 07-10-25 DD
IPP Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	54.9100	0.129	1.629474			

M5052H32S 090

5052-H32 .090 Sheet

**

Jm 12-6-20

Location

Loc Qty

Loc Code

MAT022

54.91

118641

11.22

121780

32

3019

11.69

3019

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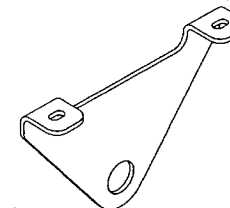
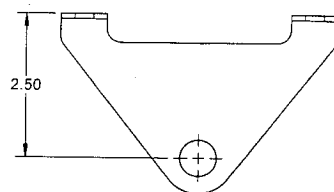
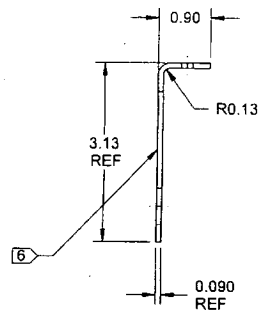
Dart Aerospace Ltd

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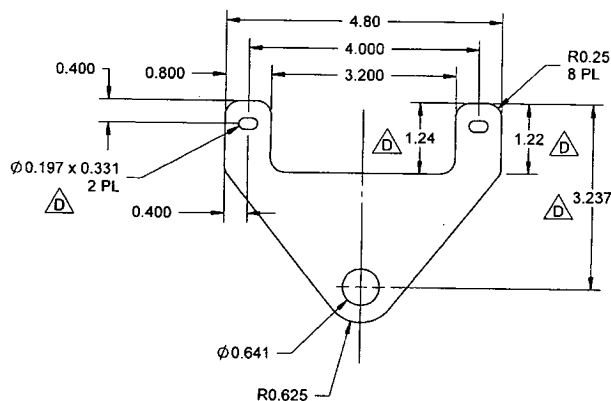
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D2052 BRACKET



D2052F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85865 MW

12/06/18

GRAIN DIRECTION

RELEASED
08-05-13/14

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

D	WIDEN SLOT (ZN B7-1); UPDATE FLAT PATTERN DIMENSIONS (ZN B5-1, B6-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANTEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A8-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)	PH	08.04.28
C	ADD FLAT PATTERN	RF	99.04.30
B	ADD SLOT TO FOOT	BW	97.02.21
A	NEW ISSUE	BW	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	RP	DRAWING NO.	REV. D
MFG. APPR.	RP	D2052	SHEET 1 OF 1
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	BRACKET	NTS
DATE	08.04.28	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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